

Work Order ID 55357

January 13, 2010 2:46:15 PM



Page 1

Item ID: D3947-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Lower LH Post

Start Date: 1/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *PL*

Date: 10-1-13

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3947

A

100

0.00



HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

PL 10/01/13 (X)

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-up

2-Pre-heat tool

3-Thermoform as per Dwg. D3947-3 and Folio FTA 046 using tool DT9484.

Dwg. Rev. *A*

Folio Rev. *A*

PL 10/01/13 (X)

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January 13, 2010 2:46:15 PM

Page 2

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Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

DL 10/01/13 (X)

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

BB 10/01/13 (X)

140

HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3946-1

WL 10/01/14 (X)

Work Order ID 55357

January 13, 2010 2:46:15 PM

Page 3

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Start Date: 1/13/10 Start Qty: 1.00

Required Date: 1/19/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

OK 10/01/14 (X)

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8.10.6.1.1.8

(X)

170

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

10-1-18 (X) SP

Work Order ID 55357

January 13, 2010 2:46:15 PM

Page 4

Item ID: D3947-3

Accept

Revision ID:

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Start Date: 1/13/10 Start Qty: 1.00

Required Date: 1/19/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/19 *[Signature]*
MF
10-1-18

Picklist Print

January 13, 2010 2:46:19 PM

Page 1

Work Order ID: 55357



Parent Item: D3947-3



Parent Item Name: Panel, Lower LH Post

Start Date: 1/13/10

Required Date: 1/19/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	749.8927	3.6253			



GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

MAT

749.8926526

107574

16.62

111973

190.526053

112176

542.7466

3,444 sq. ft. OK 10/01/13 (X)

55357 *AK*

DART AEROSPACE LTD	Work Order:	55356
Description: Panel, Lower LH	Part Number:	D3947-3
Inspection Dwg: D3947 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *DP*

Date: *10/01/13*

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	<i>0.6"</i>	✓			
1.8	Min	<i>1.96"</i>	✓			
0.050	Min	<i>0.053"</i>	✓			
0.065	Min	<i>0.067"</i>	✓			
22.5	REF	<i>22.5"</i>	✓			
10.8	REF	<i>11.25"</i>	✓			

Measured by: *DP*

Date: *10/01/14*

Audited by: *DP*

Date: *10/01/14*

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>







